

Work Order ID 82663

82663

Page 1

April-04-12 1:52:58 PM

Item ID: D3202-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cover

Stop ***NS2***

Start Date: 04/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3202	Rev D
-------	-------

100

0.00

100

Waterjet

Memo

0.00 B12-4-12

FLOW CNC Waterjet

1-Cut as per Dwg D3202

Dwg Rev: B

Prog Rev: D

5052 0.032

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Schulz

120

QC

Memo

0.00

Quality Control

(414)

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

14 6 12/4-12

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
320 F
12:30

14 X 12/04/14

M 117338

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Page 3

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				14	0	12-04-16	
Quality Control									
160	Identify as per dwg & Stock Location: ST 241A	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

(14x)

SQ
12-04-16

12/4/17

12-04-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-04-12 1:53:02 PM

Page 1

Work Order ID: 82663

82663

Parent Item: D3202-1

D3202-1

Parent Item Name: Cover

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM
 IPP Rev:C Now on Waterjet 07-04-18 JLM
 IPP Rev:D chg to revC as per dwg 08-04-21 DD verified
 by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	193.8000	1.551	16.32632	22,		

M5052H32S 032

5052-H32 .032 Sheet

**

1812-4-12

Location	Loc Qty	Loc Code
MAT022	193.8	
112664	10.4	
115638	12	
116657	20.5	
117798	20.9	
121030	34	
121040	96	

121040

(14)

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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	02663
Description: Cover		Part Number:	D3202-1
Inspection Dwg: D3202	Rev: <i>CD</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.38	+0.006/-0.001	0.384	2		✓ B22	
0.63	+/-0.030	0.628	2		✓	
3.38	+/-0.030	3.383	1		✓	
2.40	+/-0.030	2.401	2		✓	
0.82	+/-0.030	0.825	2		✓	
73.84	+/-0.030	73.84	2		T B01	
74.50	+/-0.030	74.50	1		T	
0.032	+/-0.010	0.033	2		✓	
4.03 Pitch	+/-0.030	4.026	2		✓	

Measured by: <i>RB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 12-4-12	Date: 12/04/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.09.28	Revised per Rev. B1	KJ/JLM	
C	08.07.23	Dimensions updated per Dwg Rev C	KJ/DD <i>AF</i>	<i>DD</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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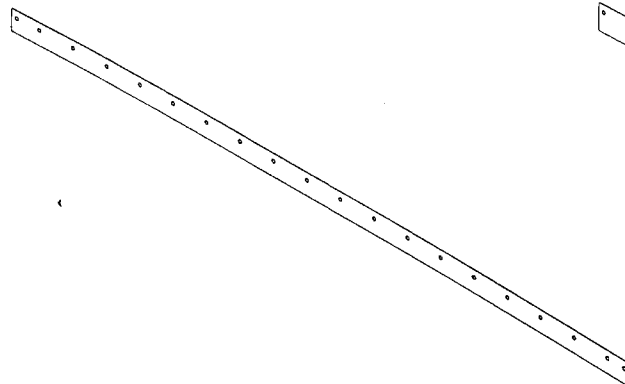
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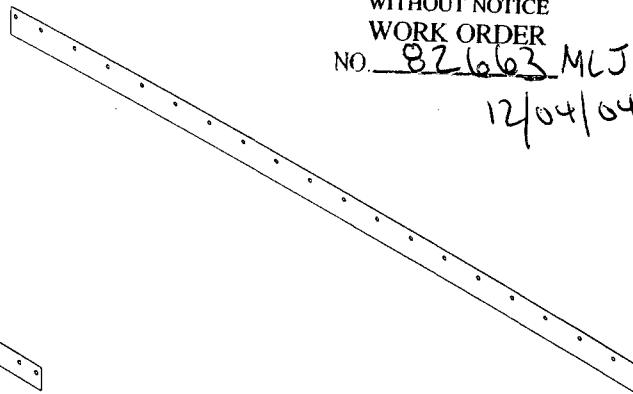
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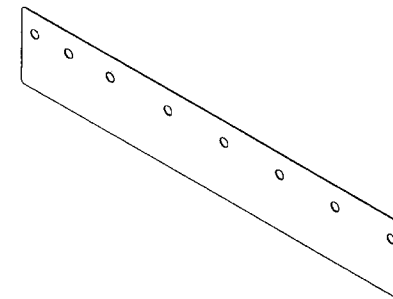
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82663 MLJ
12/04/04




D3202-1 COVER



D3202-3 COVER
(COMPOSITE DOOR)






D3202-5 COVER
(HINGE PANEL DOOR MOD) 

RELEASED
08.11.03

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3
: 0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

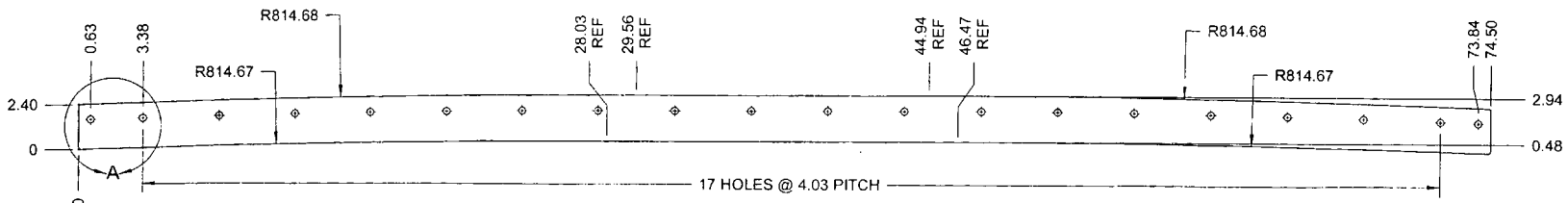
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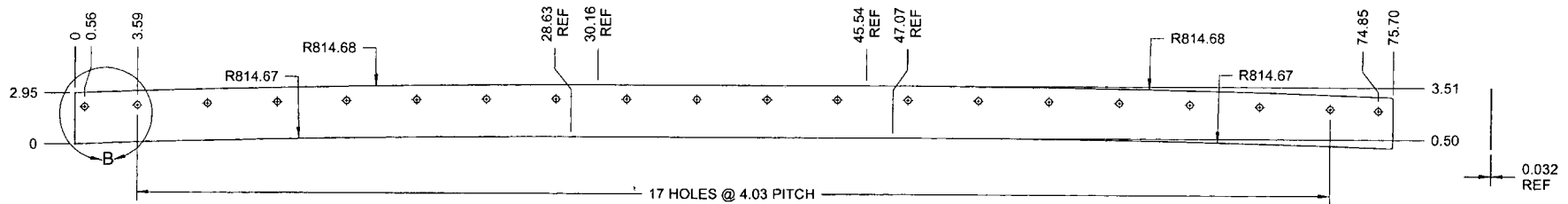
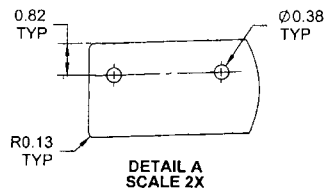
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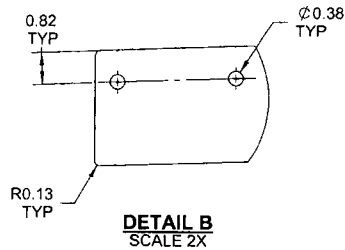
NOTE: Date & initial all entries



D3202-1 COVER



**D3202-3 COVER
(COMPOSITE DOOR)**



RELEASED
08-11-10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	MS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	FB	D3202	SHEET 2 OF 3
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DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONTAINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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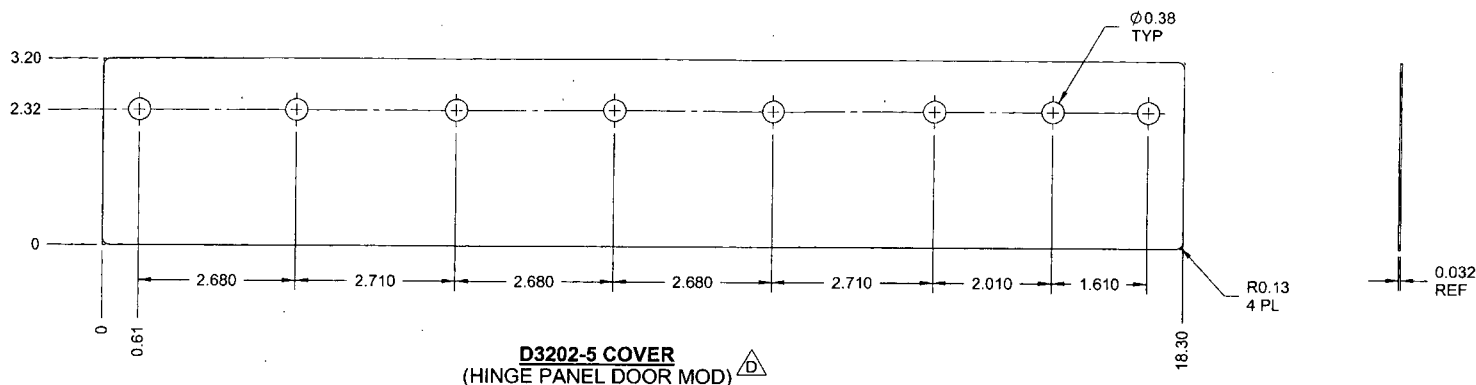
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82603



RELEASED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 3 OF 3
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DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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